

## CLAIMS

1. A garment that is made including a piece of a stretchable warp-knitted fabric comprising at least a non-elastic yarn arranged in a 1×1 tricot structure and an elastic yarn arranged in a looping structure, the piece being cut at an angle of at least 3° and at most 177° with respect to a knitting direction, and the piece having an edge that does not require hem finishing when left as cut, so that at least one of the edge portions of the garment is formed by an edge that does not require hem finishing when left as cut.

10

2. The garment according to claim 1, wherein the warp-knitted fabric comprises a 1×1 tricot structure in which the non-elastic yarn and the elastic yarn run in the same direction, and both the elastic yarn and the non-elastic yarn form open loops.

15

3. The garment according to claim 1, wherein the warp-knitted fabric comprises a 1×1 tricot structure in which the non-elastic yarn and the elastic yarn run in different directions, and at least one of the elastic yarn and the non-elastic yarn forms closed loops.

20

4. The garment according to claim 1, wherein the warp-knitted fabric comprises a 1×1 tricot structure in which the non-elastic yarn and the elastic yarn run in different directions, and both the elastic yarn and the non-elastic yarn forms closed loops.

25

5. The garment according to claim 1, wherein the structure of the elastic yarn is a half structure.

30

6. The garment according to claim 1, wherein the structure of the elastic yarn is an atlas structure.

7. The garment according to claim 5 or claim 6, made of a warp-knitted fabric in which at least one of the elastic yarn and the non-elastic yarn forms closed loops.

35

8. The garment according to claim 5 or claim 6, made of a warp-knitted fabric in which both of the elastic yarn and the non-elastic yarn form closed

loops.

9. The garment according to claim 5 or claim 6, wherein the non-elastic yarn is a cotton yarn.

5

10. The garment according to claim 5, wherein the non-elastic yarn is a cotton yarn.

10

11. The garment according to claim 5, wherein the non-elastic yarn is a cotton yarn, and at least one of the elastic yarn and the non-elastic yarn forms closed loops.

15

12. The garment according to claim 5, wherein the non-elastic yarn is a cotton yarn, and both of the elastic yarn and the non-elastic yarn form closed loops.

20

13. The garment according to claim 1, wherein the piece is a piece that is laminated by bonding at least one material selected from a group (A) consisting of (A-1) and (A-2) listed below to a material made of a cloth other than (A-1) and (A-2),

where (A-1) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and both the elastic yarn and the non-elastic yarn form closed loops;

25

where (A-2) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and one of the elastic yarn and the non-elastic yarn forms closed loops and the other one forms open loops.

30

14. The garment according to claim 13, wherein the material from which said other cloth is made is at least one material selected from a group (B) consisting of (B-1) to (B-4), where

(B-1) is a warp-knitted fabric wherein the non-elastic yarn is arranged in a 1×1 tricot structure and the elastic yarn is arranged in a half structure;

35

(B-2) is a warp-knitted fabric wherein the non-elastic yarn is arranged in a 1×1 tricot structure and the elastic yarn is arranged in an

atlas structure;

(B-3) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and both the non-elastic yarn and the elastic yarn form open loops;

5 (B-4) is a warp-knitted fabric wherein the non-elastic yarn and the elastic yarn run in different directions, and both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and form closed loops.

10 15. The garment according to claim 1, wherein the piece is a piece that is laminated by bonding together a plurality of sheets of at least one material selected from a group (B) consisting of (B-1) to (B-4), where

(B-1) is a warp-knitted fabric wherein the non-elastic yarn is arranged in a 1×1 tricot structure and the elastic yarn is arranged in a half structure;

15 (B-2) is a warp-knitted fabric wherein the non-elastic yarn is arranged in a 1×1 tricot structure and the elastic yarn is arranged in an atlas structure;

20 (B-3) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and both the non-elastic yarn and the elastic yarn form open loops;

(B-4) is a warp-knitted fabric wherein the non-elastic yarn and the elastic yarn run in different directions, and both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and form closed loops.

25 16. The garment according to claim 14, wherein the material (A) is (A-1) and the material (B) is (B-1).

30 17. The garment according to claim 16, wherein the non-elastic yarn of (B-1) is cotton, and both the non-elastic yarn and the elastic yarn form closed loops.

35 18. The garment according to any of claims 1 to 17, wherein at least one of an upper garment edge and a lower garment edge of the piece is an edge that does not require hem finishing when left as cut, and this edge not requiring hem finishing is cut at an angle of 10° to 120° with respect to the knitting direction.

19. The garment according to any of claims 1 to 17, wherein both an upper garment edge and a lower garment edge of the piece are edges that do not require hem finishing when left as cut, and these edges not requiring hem finishing are cut at an angle of 10° to 120° with respect to the knitting direction.
- 5
20. The garment according to any of claims 1 to 19, wherein the piece is made of warp-knitted fabric that is continuous in vertical direction of the garment.
- 10
21. The garment according to any of claims 1 to 20, wherein at least one of an upper garment edge and a lower garment edge of the piece is an edge that does not require hem finishing when left as cut, and this edge not requiring hem finishing is cut in a curved line.
- 15
22. The garment according to any of claims 1 to 20, wherein both an upper garment edge and a lower garment edge of the piece are edges that do not require hem finishing when left as cut, and these edges not requiring hem finishing are cut in a curved line.
- 20
23. The garment according to any of claims 1 to 21, wherein at least one of an upper garment edge and a lower garment edge of the piece is an edge that does not require hem finishing when left as cut, and this edge not requiring hem finishing has a wave shape of a plurality of curved lines.
- 25
24. The garment according to any of claims 1 to 22, wherein both an upper garment edge and a lower garment edge of the piece are edges that do not require hem finishing when left as cut, and these edges not requiring hem finishing have a wave shape of a plurality of curved lines.
- 30
25. The garment according to any of claims 1 to 24, wherein both an upper garment edge and a lower garment edge of the piece are edges that do not require hem finishing when left as cut, and the upper edge and the lower edge are not parallel to one another.
- 35
26. The garment according to any of claims 1 to 25, wherein both an upper garment edge and a lower garment edge of the piece are edges that do

not require hem finishing when left as cut, and a shape of the upper edge is different from a shape of the lower edge.

27. The garment according to any of claims 1 to 26, wherein the garment  
5 is a bottom garment, and the edge of the piece that does not require hem  
finishing when left as cut forms at least one of a waist and a bottom line.

28. The garment according to any of claims 1 to 26, wherein the garment  
10 is a bottom garment, and the edges of the piece that do not require hem  
finishing when left as cut form both a waist and a bottom line.

29. The garment according to any of claims 1 to 26, wherein the garment  
is a brassiere, or a top of a bathing suit or a leotard, and the edge of the piece  
15 that does not require hem finishing when left as cut forms at least one of an  
upper edge and a lower edge of a back cloth.

30. The garment according to any of claims 1 to 26, wherein the garment  
is a brassiere, or a top of a bathing suit or a leotard, and the edges of the piece  
20 that do not require hem finishing when left as cut form both of an  
upper edge and a lower edge of a back cloth.

31. The garment according to claim 27, wherein the edge of the piece that  
does not require hem finishing when left as cut is cut at an angle of 20° to 80°  
with respect to the knitting direction.  
25

32. The garment according to claim 28, wherein the edges of the piece  
that do not require hem finishing when left as cut are both cut at an angle of  
20° to 80° with respect to the knitting direction.

30 33. The garment according to claim 29 or 30, wherein the garment edges  
of the piece forming the back cloth that do not require hem finishing when  
left as cut are cut at an angle of 10° to 90° with respect to the knitting  
direction.

35 34. The garment according to claim 29 or 30, wherein the garment edges  
of the piece forming the back cloth that do not require hem finishing when  
left as cut being cut at an angle of 75° to 90° with respect to the knitting

direction.

35. The garment according to any of claims 1 to 34, wherein the piece is provided with a Jacquard pattern knitted into a base fabric made of the non-elastic yarn and the elastic yarn constituting the piece, by Jacquard control of another non-elastic yarn serving as the pattern yarn.

36. The garment according to claim 35, wherein the elastic yarn forming the base knit structure is arranged in a 1×1 tricot structure, and at least one of the non-elastic yarn forming the base knit structure and the non-elastic yarn serving as the Jacquard-controlled pattern yarn is arranged in a 1×1 tricot structure that runs in the same direction as the elastic yarn, and a portion forming the Jacquard pattern in the pattern yarn has a structure other than a 1×1 tricot structure.

15 37. The garment according to claim 35, wherein the elastic yarn forming the base knit structure is arranged in a 1×1 tricot structure, and one of the non-elastic yarn forming the base knit structure and the non-elastic yarn serving as the Jacquard-controlled pattern yarn is arranged in a 1×1 tricot structure that runs in the same direction as the elastic yarn, whereas the other non-elastic yarn is arranged in a 1×1 tricot structure and runs in a direction that is different to that of the elastic yarn, and a portion forming the Jacquard pattern in the pattern yarn has a structure other than a 1×1 tricot structure.

25 38. The garment according to claim 35, wherein the non-elastic yarn forming the base knit structure is arranged in a 1×1 tricot structure that runs in a direction that is different to that of the elastic yarn forming the base knit structure, and the non-elastic yarn serving as the Jacquard-controlled pattern yarn is arranged in a structure that runs in the same direction as the elastic yarn, and a portion forming the Jacquard pattern in the pattern yarn has a structure other than a 1×1 tricot structure.

35 39. The garment according to claim 1, wherein the piece is a piece that is laminated by bonding at least one material selected from a group (A) consisting of (A-1) and (A-2) listed below to a material made of a piece in which the Jacquard pattern according to any of claims 35, 36, 37 and 38 is

formed,

where (A-1) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and both the elastic yarn and the non-elastic yarn form closed loops.

where (A-2) is a warp-knitted fabric wherein both the non-elastic yarn and the elastic yarn are arranged in a 1×1 tricot structure and run in the same direction, and one of the elastic yarn and the non-elastic yarn forms closed loops and the other one forms open loops.

10

40. The garment according to any of claims 29, 30, 33 and 34, wherein the back cloth is a back cloth using a piece according to any of claims 13 to 17 and 39.

15

41. The garment according to any of claims 1 to 40, wherein the piece has a straight boundary line for a stretching power transition region due to the elastic yarn.

20

42. The garment according to any of claims 1 to 41, wherein the garment is a garment that fits the body tightly.